

Date: Tuesday, 8/14/2007 10:56:40 AM  
User: Jean-Luc Menard

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RIGHT ARM WELDMENT
Job Number	: 33890	Part Number	: D3354043
Estimate Number	: 12104	Drawing Number	: D3354 REV B
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 8/14/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: B
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: 8/14/2007 Type : LARGE FAB ASSY	Due Date	: 8/21/2007
Previous Run	: 31283	Qty:	1 Um: Each
Written By	: <i>[Signature]</i> 07-08-14		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: est rev A 06.01.25 new issue EC est rev B 07.05.14 rev B dwg Ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description								
1.0	D33543	shaft								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)</p> <p>pick:</p> <table border="0"> <tr> <td>qty</td><td>part number</td><td>description</td><td>batch</td></tr> <tr> <td>1</td><td>D3354-3</td><td>shaft</td><td>✓ B30399</td></tr> </table> <p><i>Pl 07-08-14</i> ①</p>			qty	part number	description	batch	1	D3354-3	shaft	✓ B30399
qty	part number	description	batch							
1	D3354-3	shaft	✓ B30399							
2.0	D33545	right arm								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)</p> <p>pick:</p> <table border="0"> <tr> <td>qty</td><td>part number</td><td>description</td><td>batch</td></tr> <tr> <td>1</td><td>D3354-5</td><td>right arm</td><td>✓ B30400</td></tr> </table> <p><i>Pl 07-08-14</i> ①</p>			qty	part number	description	batch	1	D3354-5	right arm	✓ B30400
qty	part number	description	batch							
1	D3354-5	right arm	✓ B30400							
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1								
<p>Comment: LARGE FABRICATION RESOURCE 1</p> <p>1- Weld assembly as per dwg D3354</p> <p>2-Grind welds flush as per dwg D3354</p> <p><i>Pl 07-08-14</i> ①</p>										
4.0	QC9	VISUAL WELDING INSPECTION								
<p>Comment: VISUAL WELDING INSPECTION</p> <p><i>10/07/08/14</i> ①</p>										

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 33890

Part Number: D3354043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

11/07/08/14 ①

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

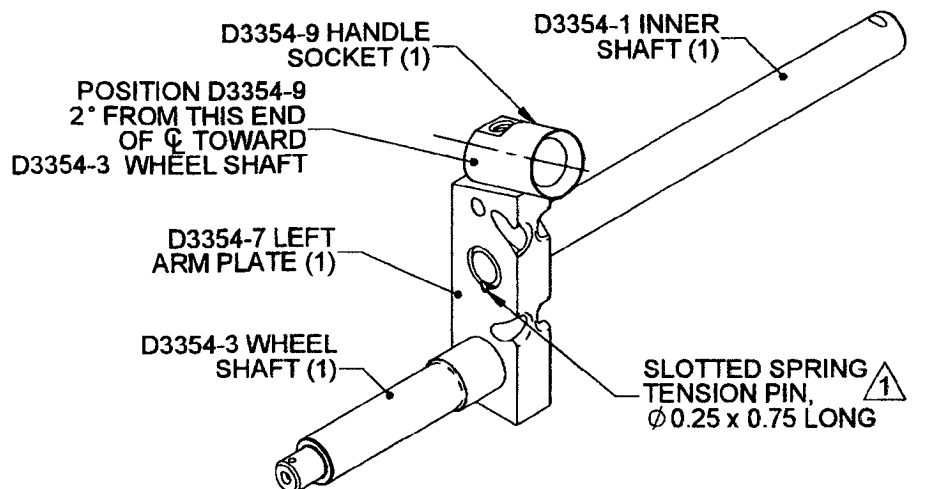


h 6712-05

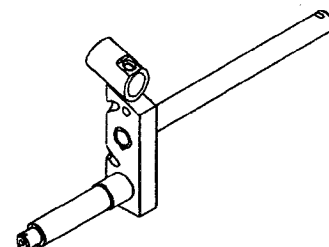


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>LEFT ARM WELDMENT</b>	REV. B SHEET 1 OF 7
DATE <b>07.02.02</b>	TITLE <b>D3354</b>	SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	

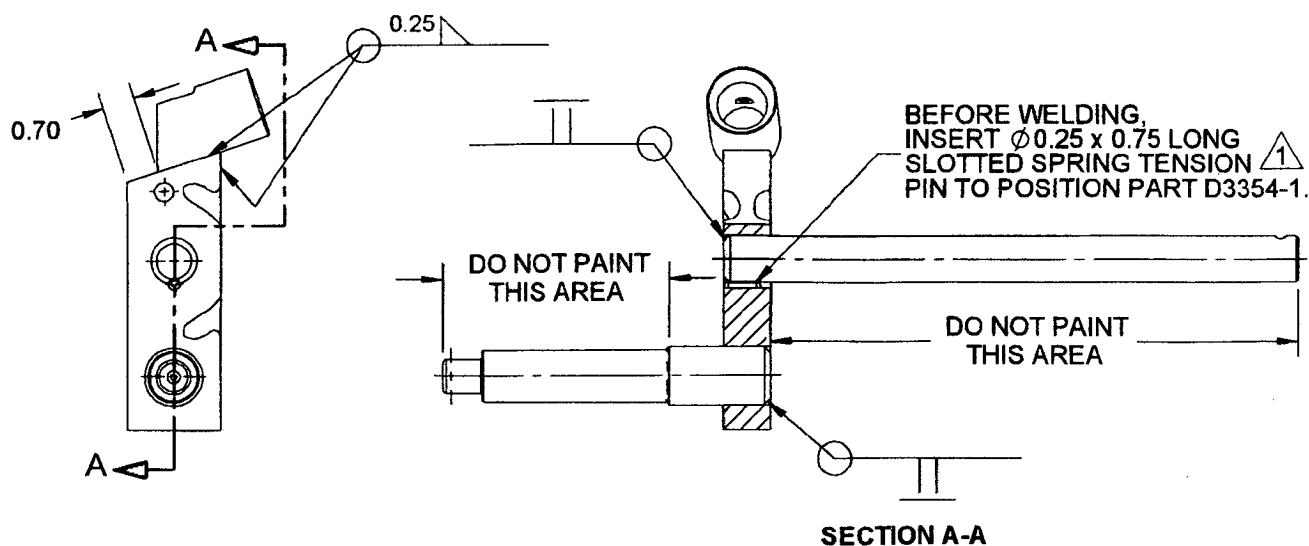
**RELEASED**  
07.02.02



**D3354-041 LEFT ARM WELDMENT**



**D3354-042 MIRROR  
ARM WELDMENT**



**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

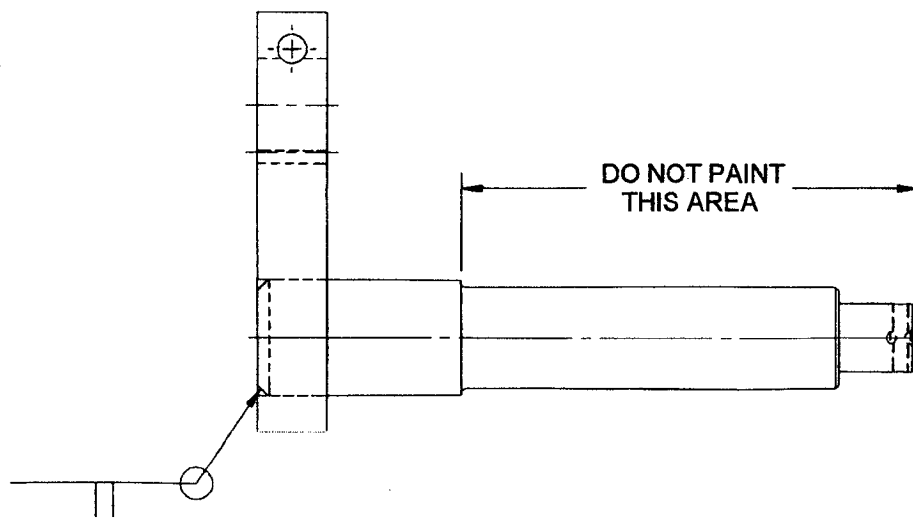
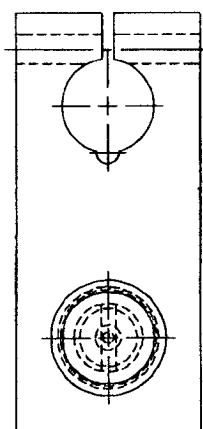
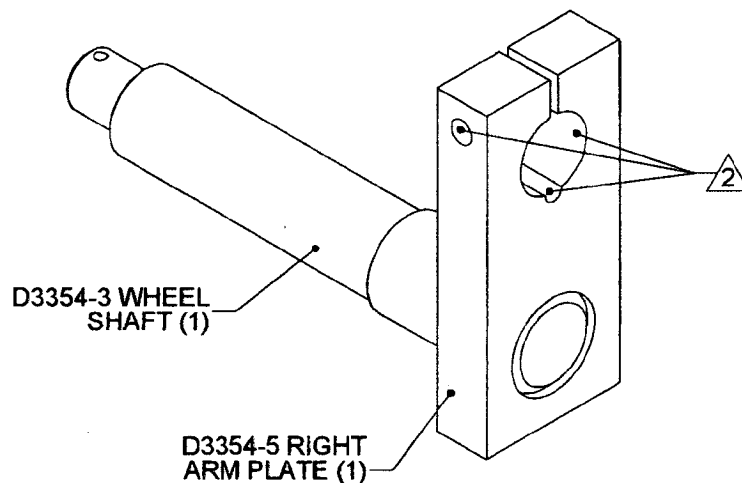
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DATE <b>07.02.02</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

RELEASED  
07.02.02



### D3354-043 RIGHT ARM WELDMENT

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

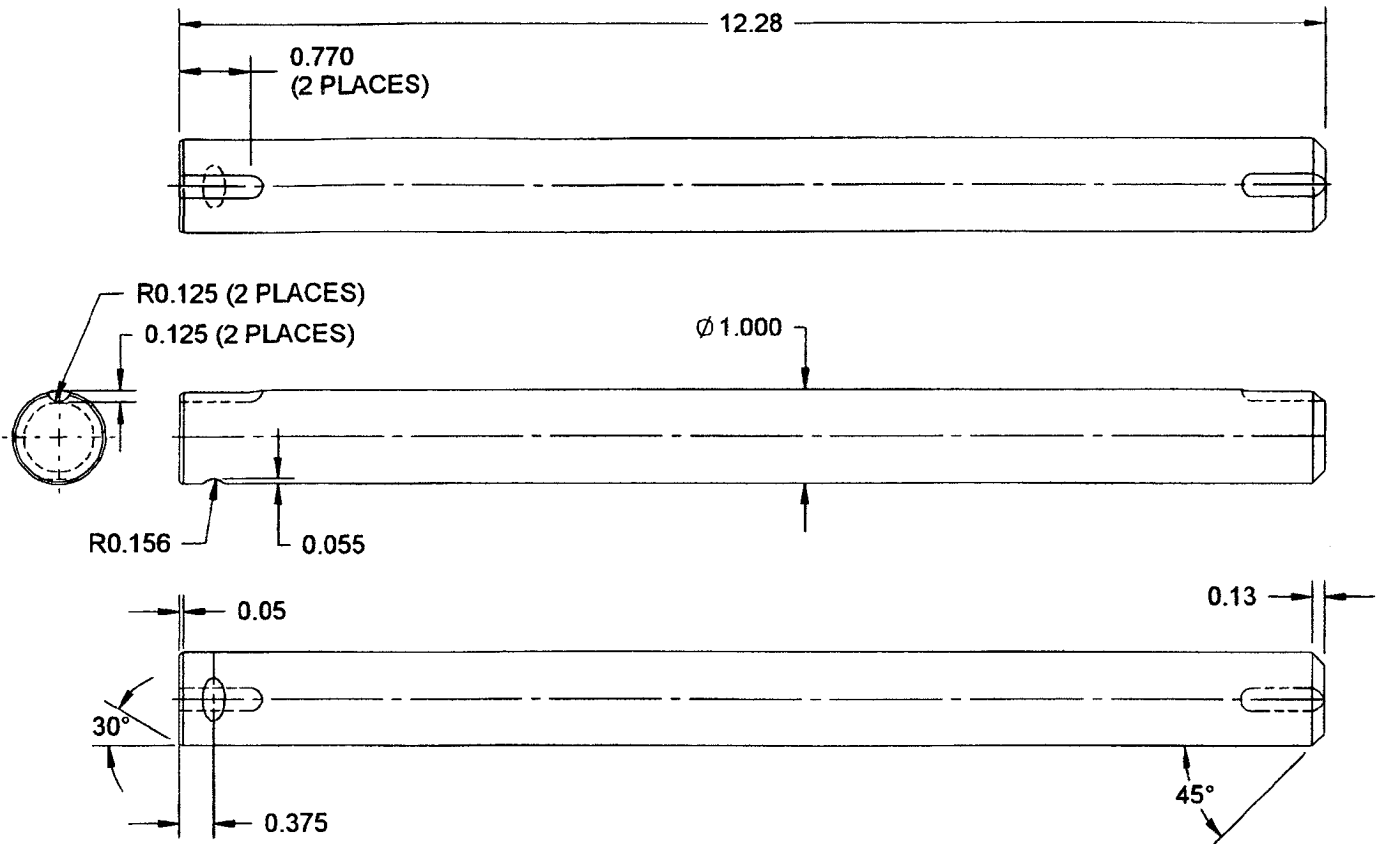
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED  
07.02.02



### D3354-1 INNER SHAFT

#### NOTES:

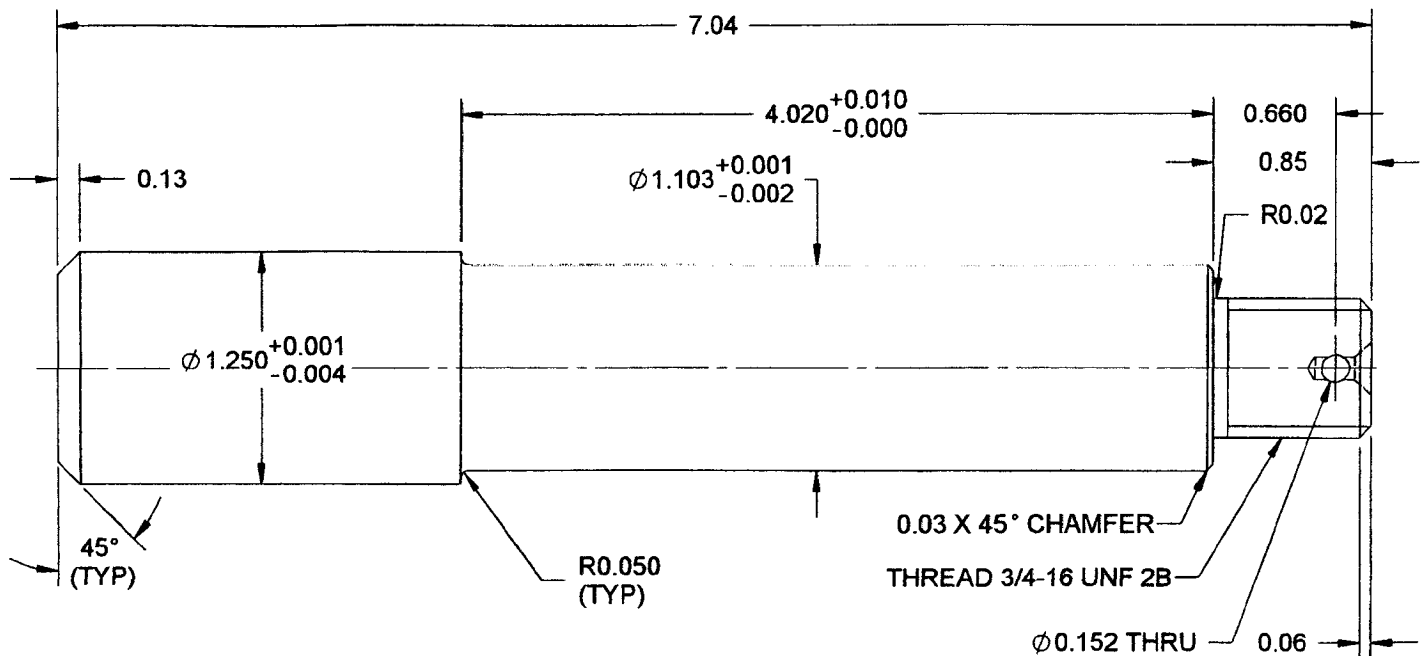
- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE <b>07.02.02</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:1

**RELEASED**  
*07.02.02***D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

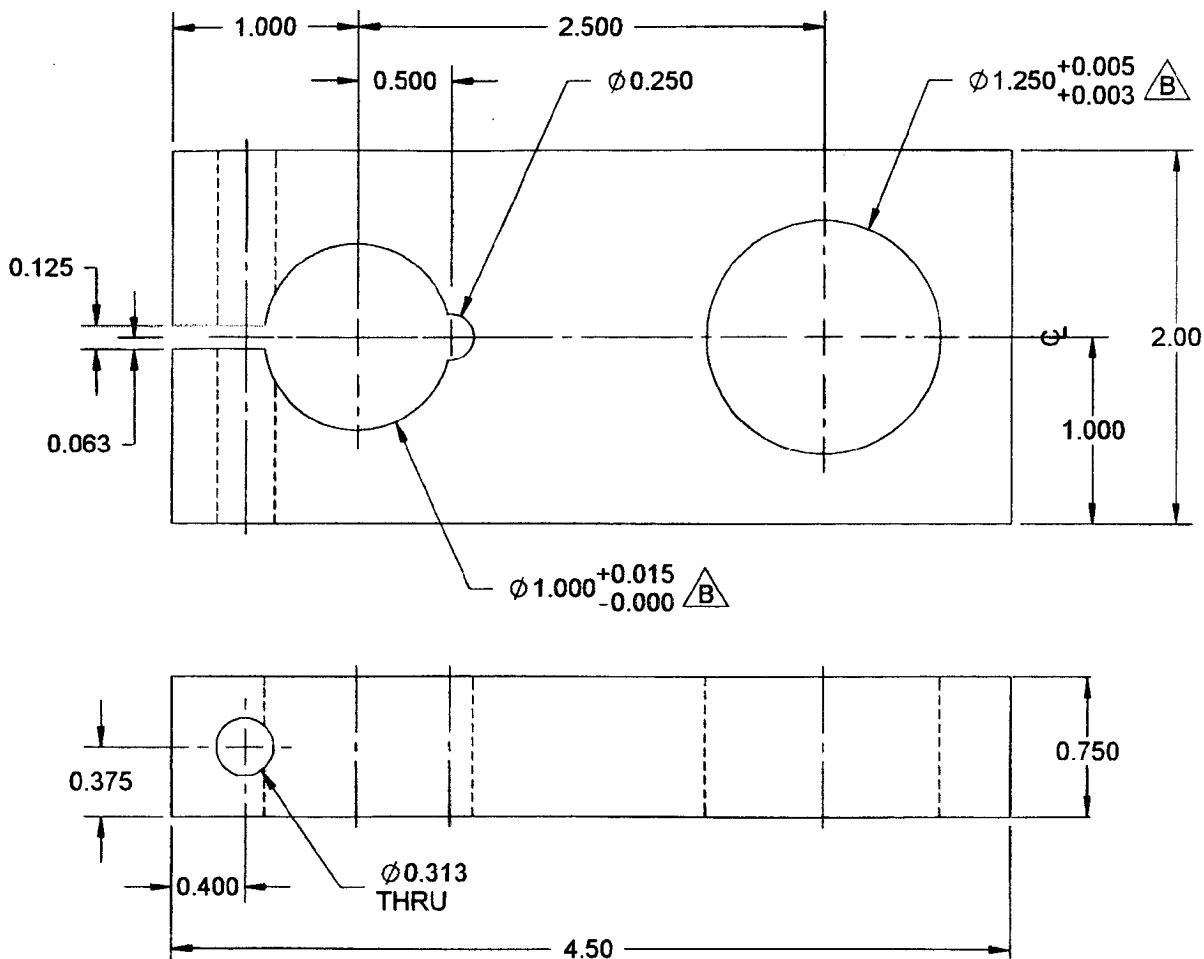
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED  
R 07.02.02



### D3354-5 RIGHT ARM PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

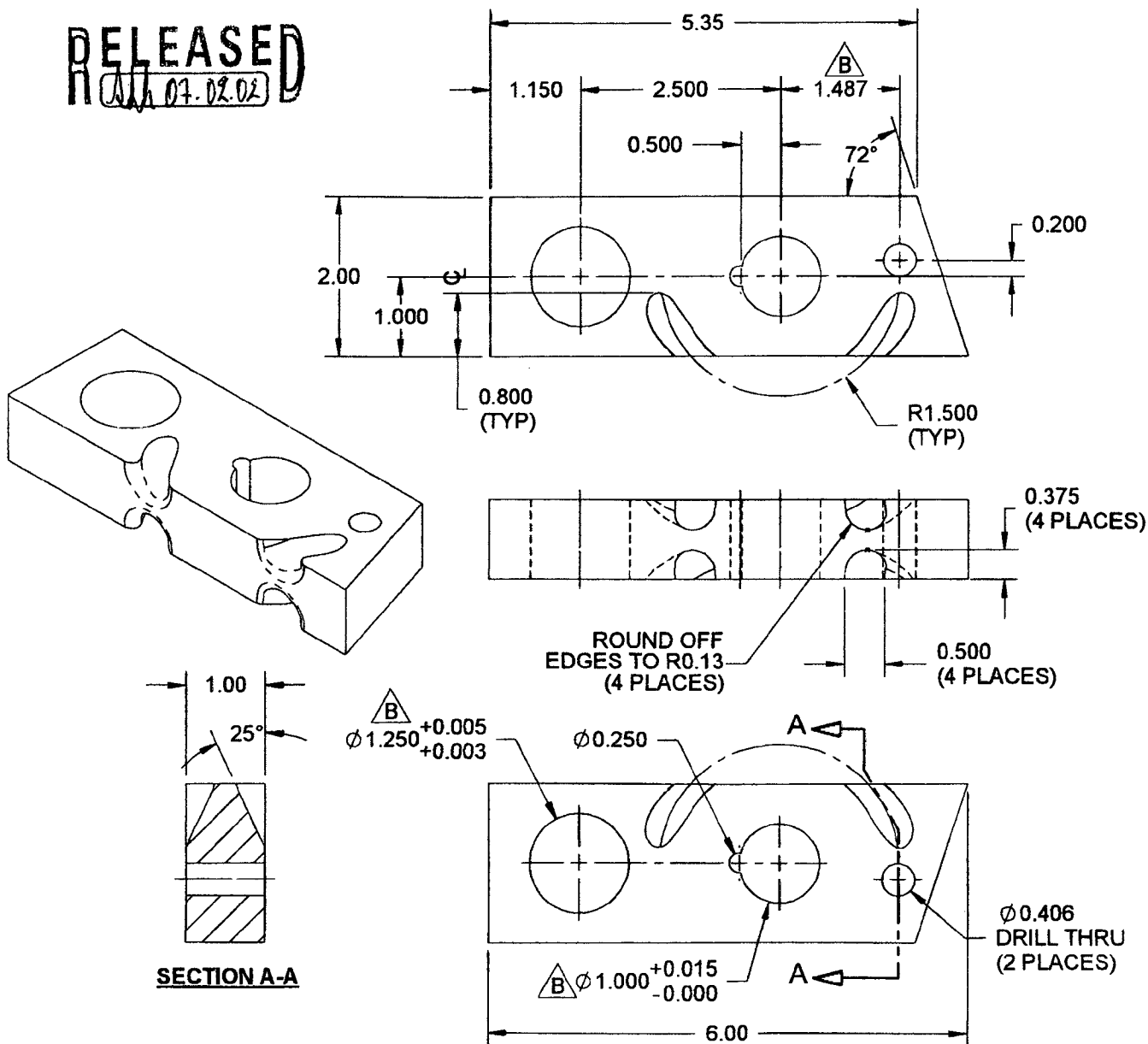
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DATE <b>07.02.02</b>	TITLE <b>LEFT ARM WELDMENT</b> SCALE 1:2		

**RELEASED**  
07.02.02



### D3354-7 LEFT ARM PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

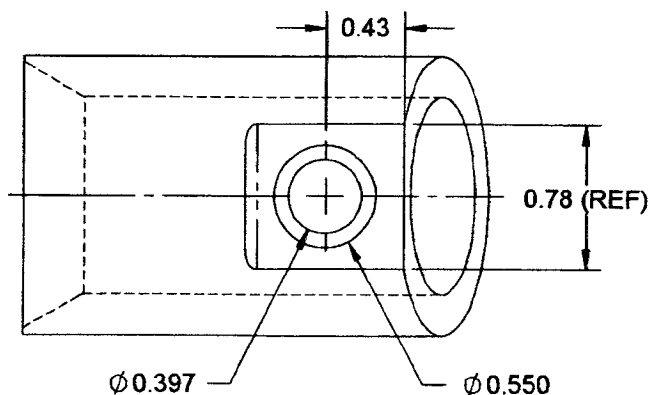
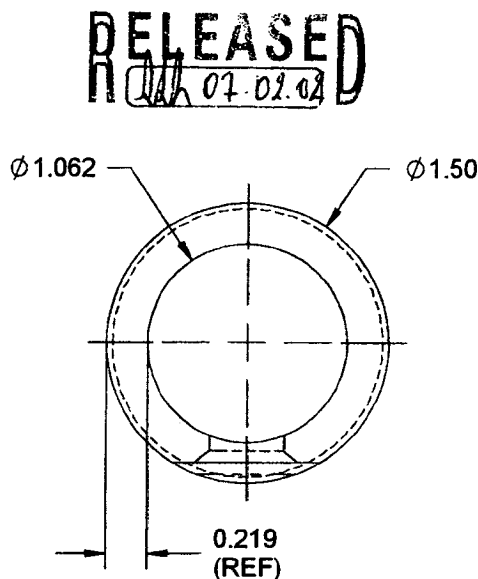
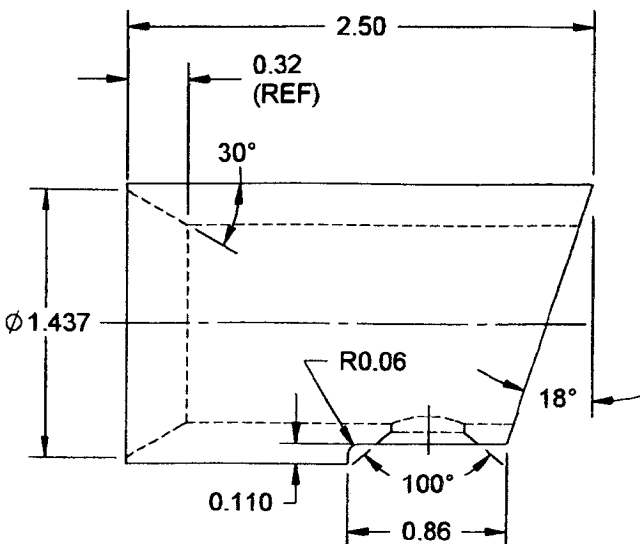
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1



### D3354-9 HANDLE SOCKET

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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